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Canada

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D350-591-312
Job Sheet 191891



DAG
21
9-59

Part No: D350-591-312

Job Qty: 10 pcs

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/11/19

Job Tracking No:

Due Date: 4/1/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	10 pcs	4/1/19		0.00	10.00	Large Fab - 1		<i>SL</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
120	QC 9	10 pcs	4/1/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
130	QC 5	10 pcs	4/1/19		0.00	0.00	QC 9 - 9		<i>19.04.01</i>
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 42		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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				QC 5 - 9	D 19.04.01
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
140	Handfinish - 1-1 Chemical-B4B	10 pcs	4/1/19	0.00 1.87	Handfinish - 1 - 1 - B4B
					Handfinish - 1 - 2 - B4B
					Handfinish - 1 - 3 - B4B
					Handfinish - 1 - 4 - B4B
					Handfinish - 1 - 5 - B4B
					Handfinish - 1 - 6 - B4B
					Handfinish - 1 - 7 - B4B
					Handfinish - 1 - 8 - B4B
					Handfinish - 1 - 9 - B4B
					Handfinish - 1 - 10 - B4B
					Handfinish - 1 - 11 - B4B
					Handfinish - 1 - 12 - B4B
					Handfinish - 1 - 13 - B4B
					Handfinish - 1 - 14 - B4B
					Handfinish - 1 - 15 - B4B
					Handfinish - 1 - 16 - B4B
					Handfinish - 1 - 17 - B4B
					Handfinish - 1 - 18 - B4B
					Handfinish - 1 - 19 - B4B
					Handfinish - 1 - 20 - B4B
					Handfinish - 1 - 21 - B4B
					Handfinish - 1 - 22 - B4B
150	QC 7	10 pcs	4/1/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41

						QC 7 - 47	
						QC 7 - 48	
						QC 7 - 51	
						QC 7 - 58	
						QC 7 - 59	
						QC 7 - 6	
						QC 7 - 60	
						QC 7 - 9	
						QC 7 - 68	DAS APR 01 2019 68
						QC 7 - 50	9-89
						QC 7 - 67	
						QC 7 - 40	
180 Large Fab - Steps - 2 - B4B	10 pcs	4/1/19	0.00	10.00		Large Fab - 1 - B4B	
						Large Fab - 10 - B4B	SLA
						Large Fab - 2 - B4B	
						Large Fab - 3 - B4B	
						Large Fab - 4 - B4B	
						Large Fab - 5 - B4B	
						Large Fab - 6 - B4B	
						Large Fab - 7 - B4B	
						Large Fab - 8 - B4B	
						Large Fab - 9 - B4B	
190 QC 10	10 pcs	4/1/19	0.00	0.00		QC 10 - 10	
						QC 10 - 18	
						QC 10 - 24	DAS
						QC 10 - 43	24
						QC 10 - 50	9-89
						QC 10 - 58	
						QC 10 - 9	
						QC 10 - 10	
200 QC 5	10 pcs	4/1/19	0.00	0.00		QC 5 - 10	
						QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 42	
						QC 5 - 43	DAS
						QC 5 - 49	24
						QC 5 - 51	9-89
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 10	
						QC 5 - 12	
210 Handfinish - 1-2- Chemical-B4B	10 pcs	4/1/19	0.00	1.87		Handfinish - 1 - 1 - B4B	
						Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 -	

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				B4B		
				Handfinish - 1 - 8 - B4B		
				Handfinish - 1 - 9 - B4B		
				Handfinish - 1 - 10 - B4B		D.R 19/04/15
				Handfinish - 1 - 11 - B4B		
				Handfinish - 1 - 12 - B4B		
				Handfinish - 1 - 13 - B4B		
				Handfinish - 1 - 14 - B4B		
				Handfinish - 1 - 15 - B4B		
				Handfinish - 1 - 16 - B4B		
				Handfinish - 1 - 17 - B4B		
				Handfinish - 1 - 18 - B4B		
				Handfinish - 1 - 19 - B4B		
				Handfinish - 1 - 20 - B4B		
				Handfinish - 1 - 21 - B4B		
				Handfinish - 1 - 22 - B4B		
220	Powdercoat - 1 White Gl(A)- B4B	10 pcs	4/1/19	0.00	2.98	Powdercoat - 1 - B4B
						Powdercoat - 2 - B4B
						Powdercoat - 3 - B4B
						Powdercoat - 4 - B4B
230	Handfinish - 3-1- WingWalk- B4B	10 pcs	4/1/19	0.00	1.87	Handfinish - 3 - 1 - B4B
						Handfinish - 3 - 2 - B4B
						Handfinish - 3 - 3 - B4B
						Handfinish - 3 - 4 - B4B
						Handfinish - 3 - 5 - B4B
240	QC 3	10 pcs	4/1/19	0.00	0.00	QC 3 - 10
						QC 3 - 13
						QC 3 - 15
						QC 3 - 17
						QC 3 - 18
						QC 3 - 2
						QC 3 - 26
						QC 3 - 28
						QC 3 - 3
						QC 3 - 30
						QC 3 - 34
						QC 3 - 36
						QC 3 - 41
						QC 3 - 51
						QC 3 - 58
						QC 3 - 59
						QC 3 - 6
						QC 3 - 68

B19-048

ML 19-4-9

APR 10 2019 68

				QC 3 - 9		
				QC 3 - 40		
250	Packaging 1-1 - Pick Kit - B4B	10 pcs	4/1/19	0.00	0.00	Packaging 1 - 1 - B4B
						Packaging 1 - 2 - B4B
						Packaging 1 - 3 - B4B
						Packaging 1 - 4 - B4B
						Packaging 1 - 5 - B4B
						Packaging 1 - 6 - B4B
						Packaging 1 - 7 - B4B
						Packaging 1 - 8 - B4B
						Packaging 1 - 9 - B4B
						Packaging 1 - 10 - B4B
						Packaging 1 - 11 - B4B
						Packaging 1 - 12 - B4B
						Packaging 1 - 13 - B4B
						Packaging 1 - 14 - B4B
						Packaging 1 - 15 - B4B
						Packaging 1 - 16 - B4B
						Packaging 1 - 17 - B4B
						Packaging 1 - 18 - B4B
						Packaging 1 - 19 - B4B
						Packaging 1 - 20 - B4B
						Packaging 1 - 21 - B4B
						Packaging 1 - 22 - B4B
						Packaging 1 - 23 - B4B
						Packaging 1 - 24 - B4B
						Packaging 1 - 25 - B4B
						Packaging 1 - 26 - B4B
						Packaging 1 - 27 - B4B
						Packaging 1 - 28 - B4B
						Packaging 1 - 29 - B4B
						Packaging 1 - 30 - B4B
						Packaging 1 - 31 - B4B
						Packaging 1 - 32 - B4B
						Packaging 1 - 33 - B4B
						Packaging 1 - 34 - B4B
						Packaging 1 - 35 - B4B
						Packaging 1 - 36 - B4B
260	QC 4	10 pcs	4/1/19	0.00	0.00	QC 4 - 26
						QC 4 - 28
						QC 4 - 42
						QC 4 - 58
						QC 4 - 6
						QC 4 - 69
						QC 4 - 9
						QC 4 - 46
270	Packaging 3-1 - Stock - B4B	10 pcs	4/1/19	0.00	0.00	Packaging 3 - 1 - B4B
						Packaging 3 - 2 - B4B
						Packaging 3 - 3 - B4B
						Packaging 3 - 4 - B4B
						Packaging 3 - 5 - B4B
						Packaging 3 - 6 - B4B
						Packaging 3 - 7 - B4B
						Packaging 3 - 8 - B4B
						Packaging 3 - 9 - B4B
						Packaging 3 - 10 - B4B
						Packaging 3 - 11 - B4B
						Packaging 3 - 12 - B4B
						Packaging 3 - 13 - B4B

P.C. APR 10 2019

DAS 69 9-09

DAS 69 9-09

				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	10 pcs	4/1/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
280 QC 21 - FG	10 pcs	4/1/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - FG - 53	

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Dwg Descriptions: D3272 A/R Aluminum Rod 138572 3-Grind End Plate flush

120 - QC9- Inspect visual per QSI004- Fusion Welds

130 - QC5- Inspect part completeness to step on W/O

140 - Chemical Conversion Coat per QSI005 4.1

150 - QC7-Inspect Chemical Conversion Coat 138572

180 - Weld per dwg A/R Aluminum rod Batch: 138572 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod 138572 6-Grind End Plate flush 7-Install last rivet as per Dwg.

190 - QC10- Inspect visual per QSI004- ground welds

200 - QC5- Inspect part completeness to step on W/O

210 - Chemical Conversion Coat per QSI005 4.1

220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 2:50 OVEN TEMPERATURE: 320

FINISH TIME: 5:10 M 151749.

230 - Wing Walk as per dwg QSI005 4.4 Batch

240 - QC3- Inspect Part Finish

250 - pick kit

260 - QC4- 100% Inspect kits for completeness

270 - Identify and pack for shipping as per PPPD350-591-312 Location FG109

275 - Document Control - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

280 - QC21- Final Inspection - Work Order Release

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____		Sequence #: _____		QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread					
		Other/Details:					

009192

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	5143328
D3219-1	Plate	20 pcs (2 ea)	110-Large Fab - Steps - 1	5133950
D3272-1	Step	10 pcs (1 ea)	110-Large Fab - Steps - 1	5166225
D3065-041	Step Leg Assembly	10 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	5168662
D3066-1	Spacer	20 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	5128757
MS20600-AD4W4	Rivet	160 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	5117999
AN3-35A	Bolt	10 20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5149341
AN4-13A	Bolt	40 80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5158518
AN5-36A	Bolt	10 20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5133174
D2230-3	Mounting Lug	20 40 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5158039
D2618	Bushing	10 20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5146466
D2856-400-720	Abrasion Strip 4" X 7.20"	10 20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5151059
D3235-1	Mounting Lug	10 20 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5150059
D3278-041	Support Assembly	5 10 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5169497
MS21042L3	Nut	10 20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5154462
MS21042L4	Nut	40 80 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	5161468
MS21042L5	Nut	10 20 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5149145
NAS1149D0363J	Washer	20 40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	5150662
NAS1149D0463J	Washer	80 160 Ea (16 ea)	250-Packaging 1-1 - Pick Kit - B4B	5151445
NAS1149D0563J	Washer	20 40 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	516686

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	20	193	0
	D3219-1	20	163	0
	D3272-1	10	0	0
180-Large Fab - Steps - 2 - B4B	D3065-041	10	11	0
	D3066-1	20	167	0
	MS20600-AD4W4	160	3,553	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	20	582	0
	AN4-13A	80	1,827	0
	AN5-36A	20	130	0
	D2230-3	40	135	0
	D2618	20	200	0
	D2856-400-720	20	186	0
	D3235-1	20	240	0
	D3278-041	10	3	0
	MS21042L3	20	3,879	0
	MS21042L4	80	3,600	0
	MS21042L5	20	749	0
	NAS1149D0363J	40	920	0
	NAS1149D0463J	160	7,242	0
	NAS1149D0563J	40	1,551	0

Part Specifications

Specifications could not be found.

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- 8946 ✓
- 9070 ✓

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details: _____					

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S167604



Part: D350-591-312

Job No: 191891

Serial No/Batch: S167604

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH92-6 Issue 10, FAA STC SH967NE 0

Change Record

PAGE 1 OF 2

Part Number: D350-591-311/-312 (EURO P/N: 704A 41 640 012/-011)

Description: HELI-ACCESS STEP, HIGH SKID, LONG STEP, LH/RH

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